





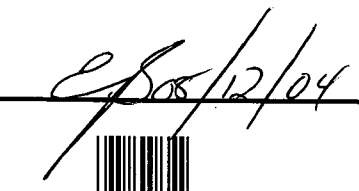
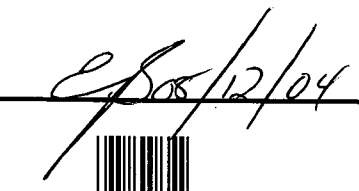
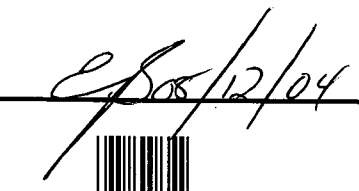

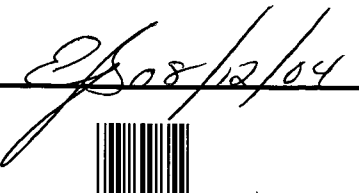
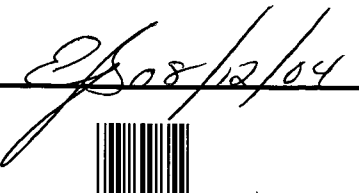
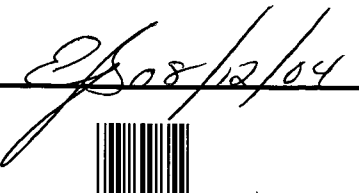


Date: Thursday, 13/11/2008 1:09:55 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: PEDAL ASSEMBLY								
<b>Job Number</b>	: 43431										
<b>Estimate Number</b>	: 11005										
<b>P.O. Number</b>	:	<b>Part Number</b>	: D412704041								
<b>This Issue</b>	: 13/11/2008 <b>S.O. No.</b> :	<b>Drawing Number</b>	: D412-704-041 REV B								
<b>Prsht Rev.</b>	: NC	<b>Project Number</b>	: N/A								
<b>First Issue</b>	: // <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b>	: B								
<b>Previous Run</b>	: 38858	<b>Material</b>	:								
<b>Written By</b>	:	<b>Due Date</b>	: 05/12/2008								
<b>Checked &amp; Approved By</b>	: <u>JUD 08.11.14</u>	<b>Qty:</b>	<u>3</u> <b>Um:</b> Each								
<b>Comment</b>	: Est Rev:B 05.01.28 Removed hardware on Step 2; Added Figures 1-3 KJ/RF Est Rev:C 06.03.08 Re-format EC Est Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20 JLM Est Rev:E 07.05.02 Reformat EC Est Rev:F 08-10-08 as per revB DD verified by:EC										
<b>Additional Product</b>											
Job Number: 											
<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>									
1.0	D3204041	Release Pedal Assembly									
											
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part number</th> <th>Description</th> <th>batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3204-041</td> <td>Pedal Assembly</td> <td>B343446 </td> </tr> </tbody> </table>				Qty	Part number	Description	batch	1	D3204-041	Pedal Assembly	B343446 
Qty	Part number	Description	batch								
1	D3204-041	Pedal Assembly	B343446 								
2.0	D32051	Pedal Bracket									
											
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part number</th> <th>Description</th> <th>batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3205-1</td> <td>Bracket</td> <td>B35854 </td> </tr> </tbody> </table>				Qty	Part number	Description	batch	1	D3205-1	Bracket	B35854 
Qty	Part number	Description	batch								
1	D3205-1	Bracket	B35854 								
3.0	D32053	Back Plate									
											
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part number</th> <th>Description</th> <th>batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3205-3</td> <td>GHW Bracket</td> <td>B35209 </td> </tr> </tbody> </table>				Qty	Part number	Description	batch	1	D3205-3	GHW Bracket	B35209 
Qty	Part number	Description	batch								
1	D3205-3	GHW Bracket	B35209 								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 13/11/2008 1:09:55 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 43431

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D32061

Pedal Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description
1	D3206-1	Pedal arm

batch

B36535 ~~35~~

*EP08/12/04*

5.0

D3209041

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description
1	D3209-.041	Bracket

batch

B37170 x 1 , B 38190 x 2.

*EP08/12/04*

6.0

AN310A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description
1	AN3-10A	Bolt

batch

M17566

*EP08/12/04*

7.0

AN3154R

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description
1	AN315-4R	Nut

batch

M17566

*EP08/12/04*

8.0

AN410A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description
1	AN4-10A	Bolt

batch

M107178

*EP08/12/04*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Thursday, 13/11/2008 1:09:55 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 43431

Part Number: D412704041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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9.0	AN412A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part number	Description	batch
2	AN4-12A	Bolt	M106918

10.0	AN413A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN4-13A	Bolt	M109285

11.0	AN960JD10	Washer
------	-----------	--------



Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part number	Description	batch
5	AN960JD10	Washer	M109061

12.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 11.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty	Part number	Description	batch
11	AN960JD416	Washer	M109249

13.0	AN960JD416L	Washer
------	-------------	--------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part number	Description	batch
3	AN960JD416L	Washer	M110002

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 13/11/2008 1:09:55 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 43431

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty	Part number	Description	batch
3	MS21042L3	Nut	M109031

*CP 08/12/04*

15.0

MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty	Part number	Description	batch
5	MS21042L4	Nut	M108445

*CP 08/12/04*

16.0

MS24694S102

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS24694S102	Screw	M14604

*CP 08/12/04*

17.0

MS951910

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS9519-10	Bolt	M100290

*CP 08/12/04*

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble pedal as per Dwg D412-704-041

Tighten & Torque Bolts as per Dwg D412-704-041

*CP 08/12/04 (3)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Thursday, 13/11/2008 1:09:55 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 43431

Part Number: D412704041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

19.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/04 (x3)

20.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

21.0	AN960JD10L	Washer
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)  
Pick:

Qty	Part number	Description
4	AN960JD10L	Washer

batch  
M105773

SP

22.0	AN36A	Bolt
------	-------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Pick:

Qty	Part number	Description
2	AN3-6A	Bolt

batch  
M109452

SP

23.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Nut  
Batch: M109031

8/12/4

3X

SP

24.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/12/04 (x3)

25.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: PPP 43368

8/12/4

3X

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 43431

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/04 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-04

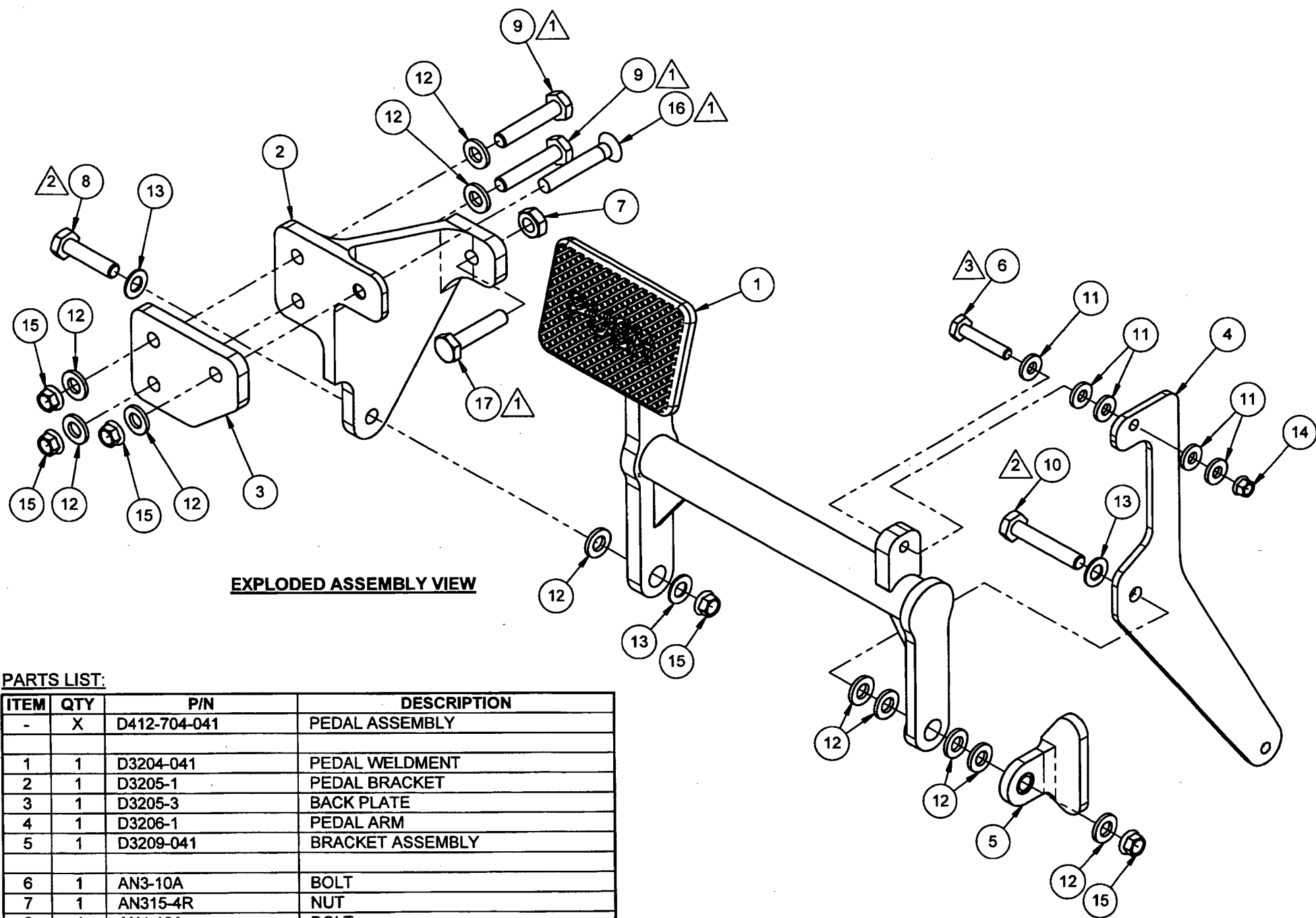
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

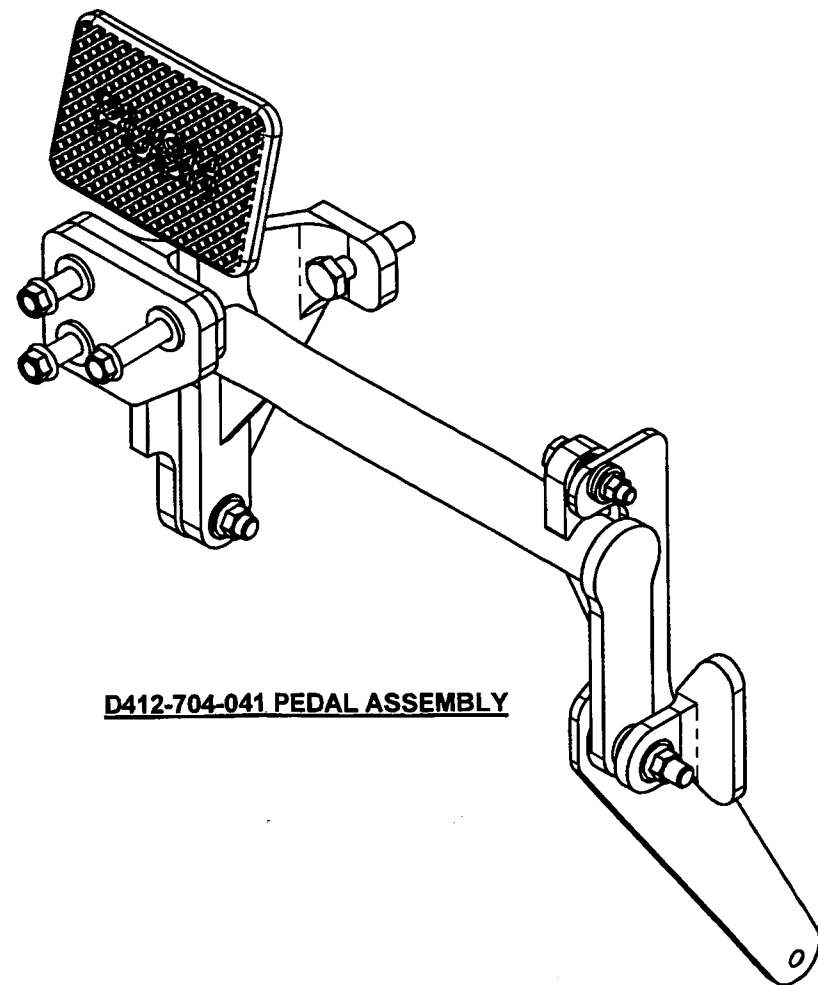
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**EXPLODED ASSEMBLY VIEW**



**D412-704-041 PEDAL ASSEMBLY**

**PARTS LIST:**

ITEM	QTY	P/N	DESCRIPTION
-	X	D412-704-041	PEDAL ASSEMBLY
1	1	D3204-041	PEDAL WELDMENT
2	1	D3205-1	PEDAL BRACKET
3	1	D3205-3	BACK PLATE
4	1	D3206-1	PEDAL ARM
5	1	D3209-041	BRACKET ASSEMBLY
6	1	AN3-10A	BOLT
7	1	AN315-4R	NUT
8	1	AN4-10A	BOLT
9	2	AN4-12A	BOLT
10	1	AN4-13A	BOLT
11	5	AN960JD10	WASHER
12	11	AN960JD416	WASHER
13	3	AN960JD416L	WASHER
14	1	MS21042L3	NUT (OR MS21042-3)
15	5	MS21042L4	NUT (OR MS21042-4)
16	1	MS24694-S102	SCREW
17	1	MS9519-10	BOLT
N/A*	2	AN3-6A	BOLT
N/A*	4	AN960JD10L	WASHER
N/A*	2	MS21042L3	NUT (OR MS21042-3)

\* SHIPPED LOOSE WITH -041 KIT (NOT PRE-ASSEMBLED AT DART)

**NOTES:**

- 1 INSTALL IDENTIFIED FASTENERS LOOSE (HAND TIGHTEN ONLY).
- 2 TIGHTEN IDENTIFIED FASTENERS UNTIL SNUG. ENSURE THAT PARTS CAN STILL ROTATE.
- 3 TORQUE IDENTIFIED FASTENERS TO 15-25 in-lbs (1.7-2.8 N-m).

A		07.01.23	NEW ISSUE
REV	DATE	DESCRIPTION	
DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
07.01.23		<b>D412-704-041</b>	SHEET 1 OF 1
TITLE		SCALE	
<b>PEDAL ASSEMBLY</b>		1:2	
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07.01.30

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